

## **CLAIMS**

16. A binding line for gathering a plurality of signatures to form a book, comprising:

a plurality of packer boxes for delivering an associated signature to be gathered to form the book;

a feeder system operatively associated with at least one of the packer boxes that includes a conveyor and a plurality of feeders, each of the feeders being adapted to deliver a distinct signature to the associated packer box; and

a controller in communication with the feeders to activate a selected one of the feeders at a time.

17. The binding line of claim 16, wherein the feeder system further includes a printer positioned to apply a predetermined printed message to a reserved portion of the signatures delivered from the feeders prior to delivery to the associated packer box.

18. The binding line of claim 17, wherein each of the signatures has a backbone and the printer applies the printed message perpendicular to the backbone.

19. The binding line of claim 17, wherein the controller is in communication with the printer to determine the content of the printed message applied to the signatures.

20. The binding line of claim 17, wherein the feed conveyor includes an output end for delivering the signatures from the feeders to the associated packer box and the printer is positioned adjacent the output end of the feed conveyor.

21. A feeder system for delivering signatures to an associated one of a plurality of packer boxes on a binding line, comprising:

a plurality of feeders each adapted to deliver a distinct signature to the associated one of the packer boxes; and

a controller in communication with each of the feeders to activate a selected one of the feeders at a time.

22. The feeder system of claim 21, including a printer for applying a predetermined customized or personalized printed message to a reserved portion of the signatures delivered from the feeders prior to delivery to the associated one of the packer boxes.

23. The feeder system of claim 21, wherein each of the signatures has a backbone and the printer applies the printed message perpendicular to the backbone.

24. The feeder system of claim 21, wherein the controller is in communication with the printer to determine the content of the printed message applied to the signatures.

25. The feeder system of claim 21, including a feed conveyor for delivering the distinct signatures from the feeders to the associated one of the packer boxes.

26. The feeder system of claim 25, wherein the feed conveyor has an output end, and the printer is positioned adjacent the output end of the feed conveyor.

27. A method for expanding the capacity of a binding line having a plurality of packer boxes, comprising the steps of:  
operatively connecting a plurality of signature feeders with an associated one of the packer boxes;  
supplying each of the signature feeders with a distinct signature; and  
controlling the feeders to deliver the distinct signatures to the associated one of the packer boxes.

28. The method of claim 27, wherein the controlling step includes programming a controller to select the distinct signature to be delivered to the packer box.

29. The method of claim 27, including the additional step of applying printed material to the distinct signatures during delivery to the associated one of the packer boxes.

30. The method of claim 29, wherein the controlling step includes programming a controller to apply customized or personalized information on the signature.